

Tuesday, April 21, 2015 1:58:03 PM

Page 1

RE-CHECK TORCQUE ON CLAMP AS PER DWG.

1 - - - - - @N15-05,9

1 CNISOS19

1 ————— 98
1.5-05-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐		
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OTHER : ☐																						

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131955

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: FWD Crosstube Installation with Step (no hardware)

Stop *NS2*

Start Date: 4/20/15 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 4/20/15 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00

150

Packaging

0.00

Packaging

Memo

Packaging

Identify and pack for shipping as per PPP D119-796-151

USED ON W/O
B132854

① S.A. 15/05/21

160

QC21- Final Inspection - Work Order Release

0.00

160

OC

Memo

0.00

Quality Control

MW MAY 21 2015

MS-5.2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Misidentified ☐	Past Due ☐																								
		OTHER : _____																							

Picklist Print

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Page 1

Work Order ID: 131955

131955

Parent Item: D119-796-151

D119-796-151

Parent Item Name: FWD Crosstube Installation with Step (no hardware)

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP
REV:B 14.11.19 AS PER REV.C DD VERF:JLM IPP REV:C
14.12.09 AS PER REV.PC6 DD VERF:JLM IPP REV:D 15-02-11
AS PER REV D JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D119-796-141

Manufactured

No

Each

0.0000

1

D119-796-141

FWD Crosstube Installation without Step (no hardware)

D5123-3

Manufactured

No

Each

24.0000

4

D5123-3

Clamp Cushion

Location

lg55

Loc Qty

24

Loc Code

126747

16

127133

6

131009

2

D5149-041

Manufactured

No

Each

4.0000

2

D5149-041

Fwd Step Base Assembly

Location

LG

Loc Qty

4

Loc Code

131331

4

MS21920-22

Purchased

No

Each

90.0000

4

MS21920-22

Clamp

Location

LG050

Loc Qty

90

Loc Code

M128636

3

M130822

12

M132045

75

131544

131871

CA 15-05-19

CA 15-05-19

CA 15-05-19

CA 15-05-19

DQA: _____ Date: _____



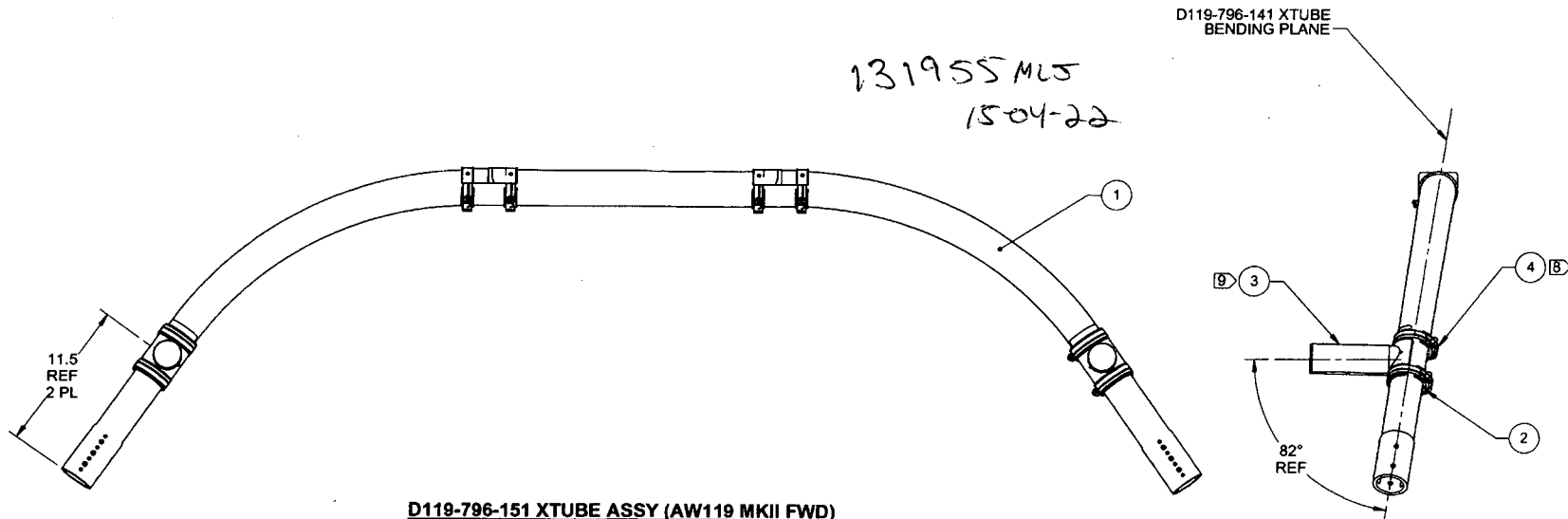
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Date :	Step #:	QTY Effective :		MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
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		OTHER : _____			

ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
1	1	D119-796-141	XTUBE ASSY (AW119 MKII FWD)
2	4	D5123-3	CUSHION
3	2	D5149-041	FWD STEP ASSEMBLY
4	4	MS21920-22	CLAMP



D119-796-151 XTUBE ASSY (AW119 MKII FWD)

RELEASED

2015 FEB 09

ECN 15-516

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 19.87 lbs
- 8) TORQUE MS21920-22 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE

D	D5123-3 CLAMP CUSHION WAS D5123-9 CLAMP CUSHION, MS21920-22 WAS -24.	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D5149-043 WAS D5149-041, AN4C8A WAS AN4C10A, D2274 WAS D5153-1	AP	14.11.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP		
DRAWN	AP		
CHECKED	DB		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS		
DATE	15.01.19		

APPROVED

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D119-796-151

TITLE
XTUBE ASSY (AW119 MKII FWD)

REV. D
SHEET 1 OF 1
SCALE
NTS

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